

Date: Thursday, 3/9/2006 9:22:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 26186	
Estimate Number : 10743	
P.O. Number : N/A	Part Number : D33152
This Issue : 3/9/2006 S.O. No. : N/A	Drawing Number : D3315 REV A PRELIM PH 05.03.03
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A-B 05.03.03 PH
Previous Run : 24703	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 3/16/2006 Qty: 5 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment : Est: A 05.05.12 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 521

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3315

Possible Supplier: Industrial Laser

Material release note is required

u 06-02-06

the from 25725

2.0	D33152F	Wearplate Flat Pattern
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206/02/22 (5)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3315-2T2

PH 06.02.08

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

06-03-09 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 9:22:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26186

Part Number: D33152

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8751 Die as per Dwg D3315 Rev: B

2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315 Rev: B

060309

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev: B

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M/00299

CPL 06-03-27

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/03/22

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/24

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C 206/03/24

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-2, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: ✓

PDA05-17 06.03.09

C 206/03/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-14	8	Took 1x D3315-2 workplate to make D3315-2T3 welding template Inspected by: <i>[Signature]</i> 06-03-14	CPL	06-03-14	1	<i>[Signature]</i> 06-03-14	<i>[Signature]</i> 06-03-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/03/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 9:22:51 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26186

Part Number: D33152

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



(4)

Comment: DOCUMENT CONTROL
Inspection Level 21

06/03/24

Job Completion



u 06/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

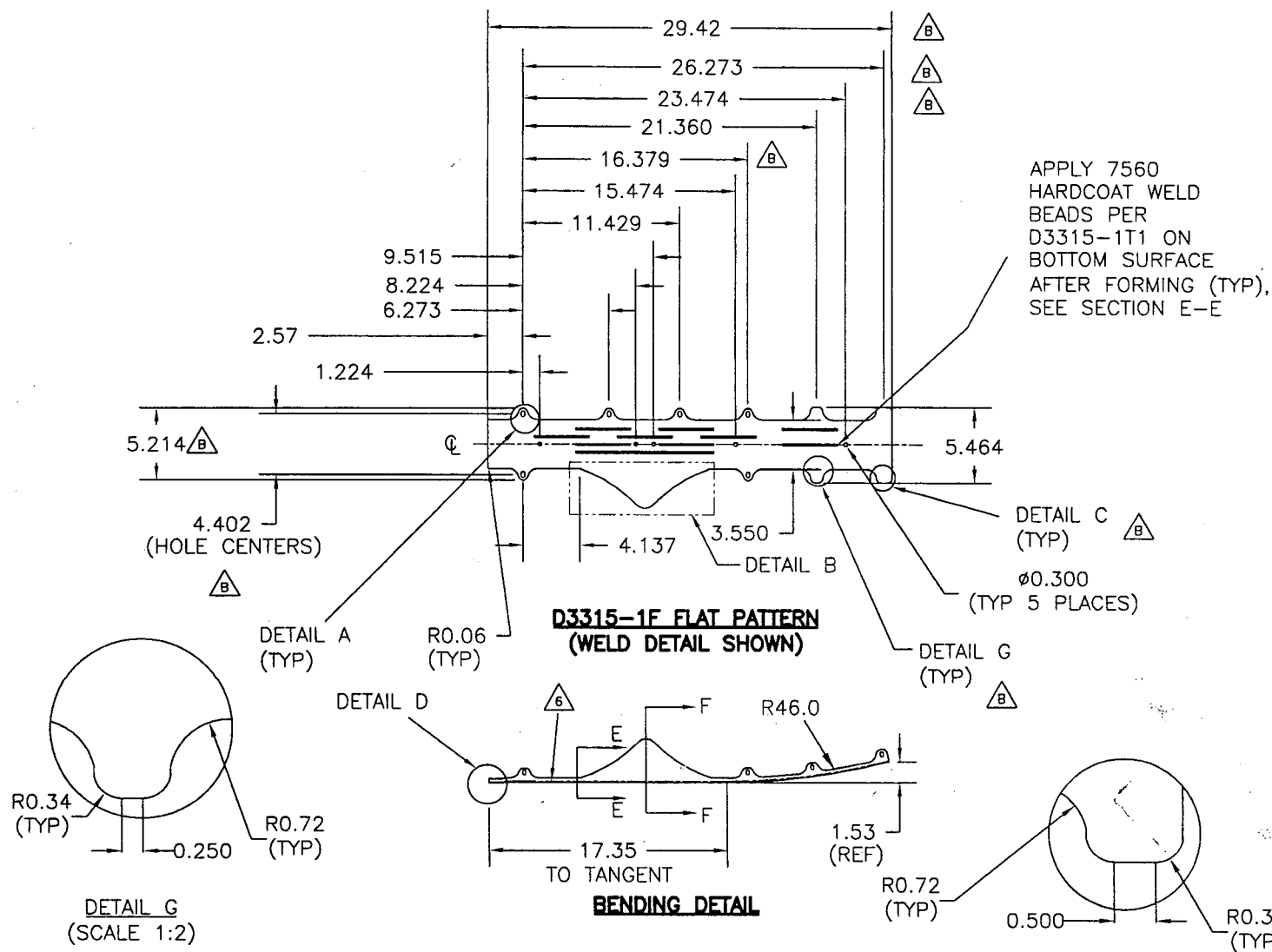
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
05.07.32

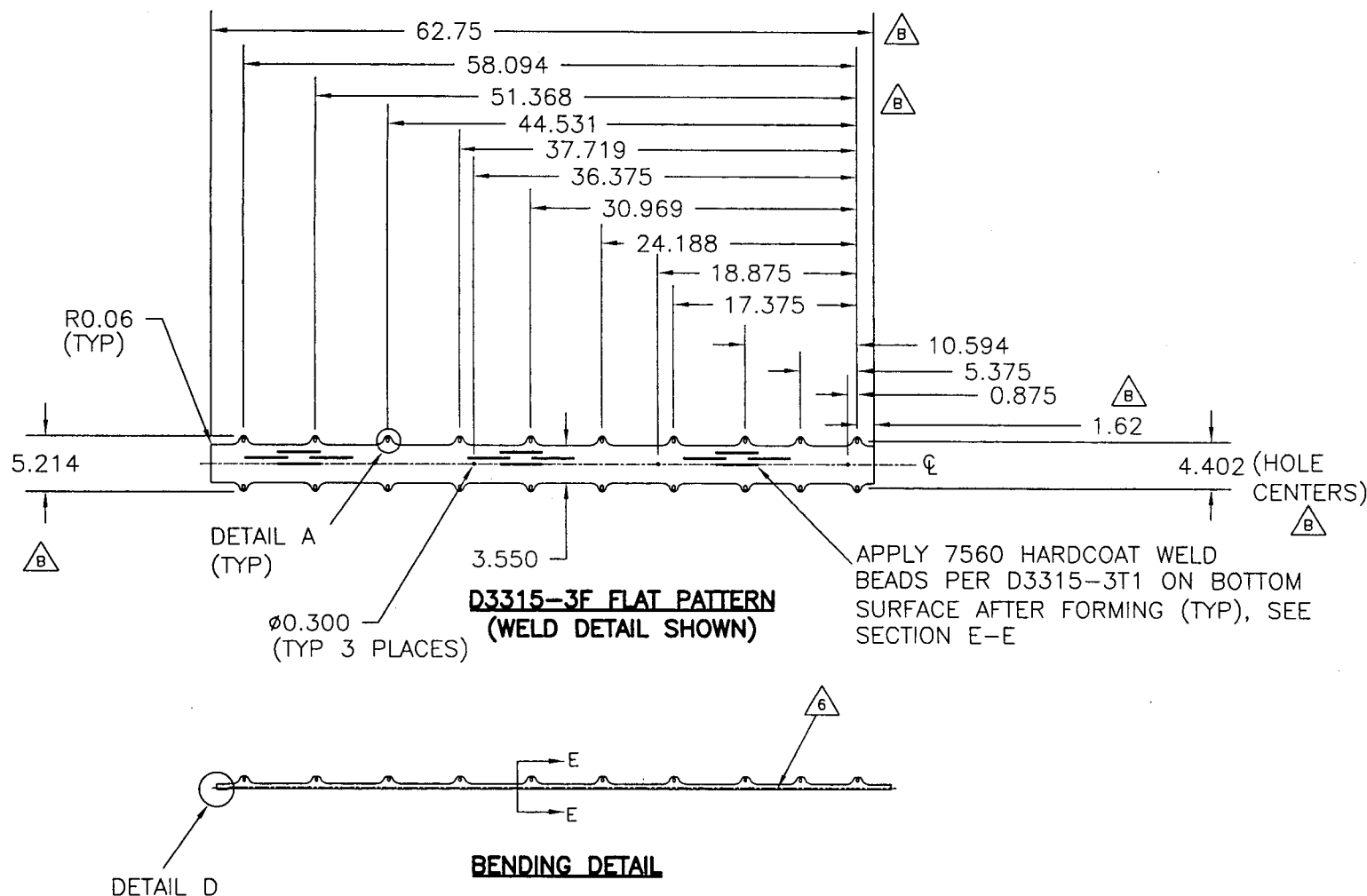
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3315
DATE 06.01.31		TITLE WEARPLATE
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS
		REV. B SHEET 1 OF 4 SCALE 1:12



D3315-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.01.31



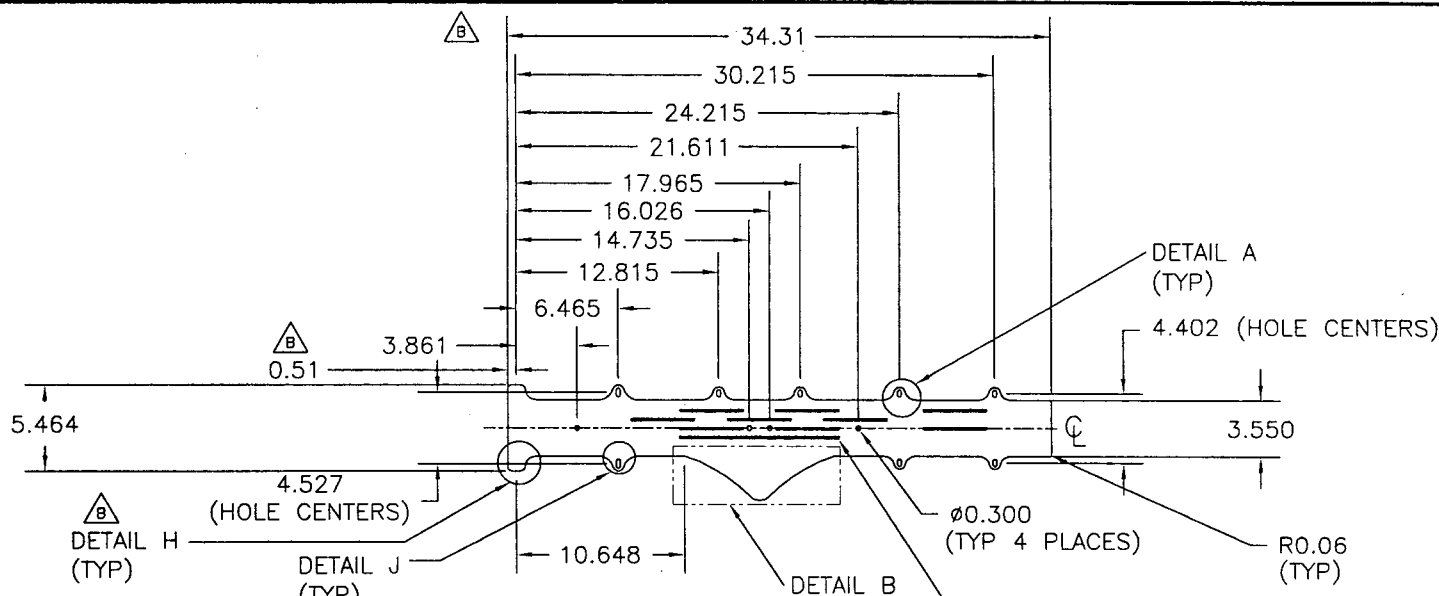
BENDING DETAIL

D3315-3 WEARPLATE (SHOWN, -4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

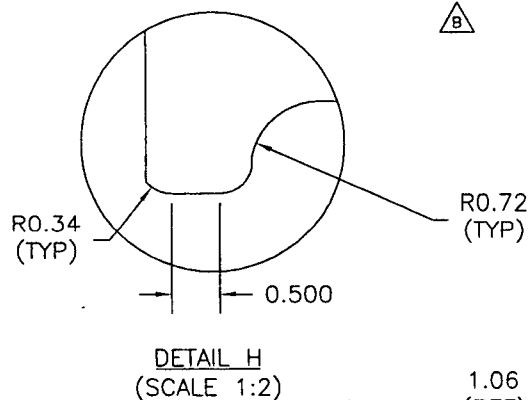
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
06.01.31	D3315	SHEET 2 OF 4
	TITLE	SCALE
	WEARPLATE	1:16

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.02.37 *RH*



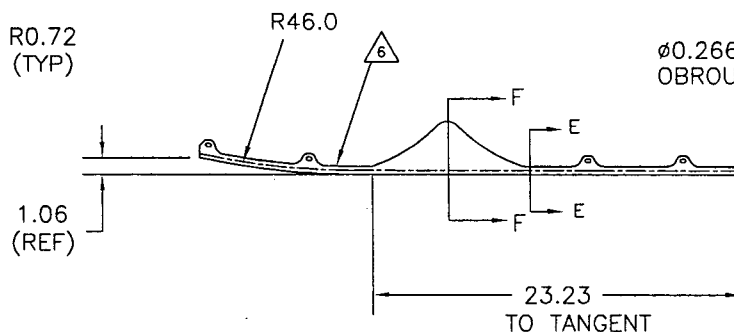
**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



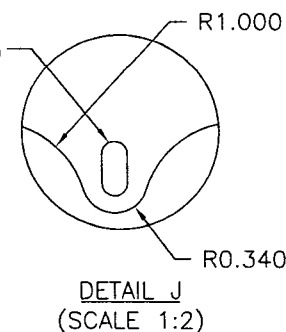
R0.72
(TYP)

DETAIL H
(SCALE 1:2)



BENDING DETAIL

Ø0.266 X 0.575
OBSROUND



DETAIL J
(SCALE 1:2)

D3315-5 WEARPLATE (SHOWN, -6 OPPOSITE)

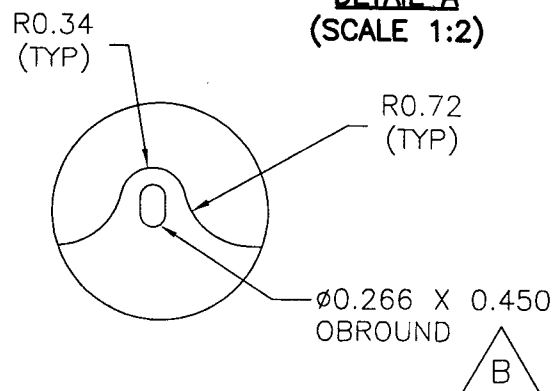
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
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"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3315
DATE 06.01.31	TITLE WEARPLATE	REV. B SHEET 3 OF 4 SCALE 1:12

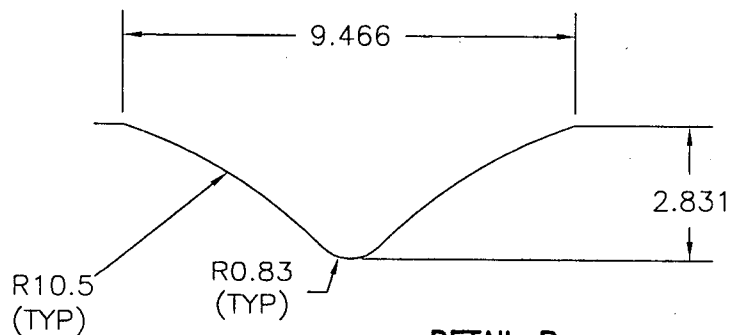
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06-02-37 PH

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3315	SHEET 4 OF 4
06.01.31		TITLE	SCALE
		WEARPLATE	NTS

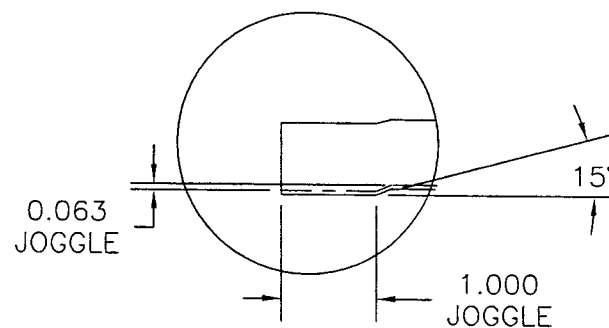
DETAIL A
(SCALE 1:2)



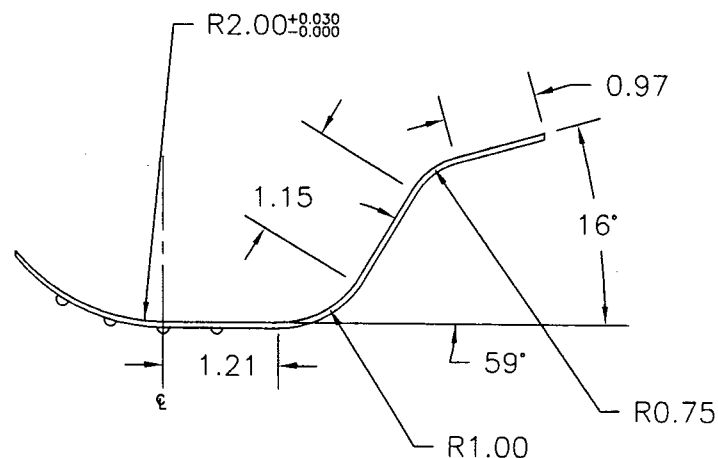
DETAIL B
(SCALE 1:4)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

